120

QC2- Inspect parts off machine FAI/FAIB

0.00

\*120\*

Memo

0.00

Quality Control

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B12-11-27

												DQA:_	Date:	
NCR:	Yes	/ No					WORK ORDER NON-C	100	NFORI	MANCE / UPD	ATE			
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Nork Ord	er:						DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
Part I	Part No.					Scrap Machining Small Fab			Crosstube Small Fab Finishing	1	Water Jet  J. Eng. Coor.  e/Packaging	Engineering Quality Other		
NCR No.						Work Order Update	]		тЩ	Composite	·	Supplier		
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Cause		Date	Step	Qty		o	r Non-conformance	Ch	ief Eng	Descrip	otion	Date	Verification	QC Inspector
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		Cuffs			L		Contamination		Mainte	enance		Part Moved		
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		Inspection	n Strip in	Tube		$\Box$	Cut Too Short		Misread	i		Power Loss/S	Surge	Other
		Ripples in	Bend				Drill Holes		Offset					
		Torque W	aves in E	xtrusio	n [		Drawing		Out of (	Calibration				
		Turning Se	eauence			$\neg$	Finish		Out of	Sequence				

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Work Order ID 93423 Page 2 November-19-12 10:07:13 AM Item ID: 646.3912 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Shim **Start Oty:** 80.00 **Start Date:** 11/15/12 **Cust Item ID:** Required Date: 12/07/12 Req'd Qty: 80.00 **Customer:** Reference: Run Process Plan: Date: Tooling: **Approvals:** Date: QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Run Hoals **Work Center ID** Qty **Description** Code Qty Number Stamp 130 QC8- Inspect parts - second check \*130\* Memo Quality Control 140 Outsource process-Cadplate per QSI017 4.1.9.1 0.00 pl 12-5-12 \*140\* Outsource3 0.00 Memo Outsource process - Cad plate 150 Receive & Inspect for Damage & Mat'l Certs 0.00 \*150\* Packaging 0.00 Memo

Packaging

NCR:	Yes	1	Nο

												DQA:_	Date:	
NCR:	Yes	/ No					WORK ORDER NON-C	100	NFORI	MANCE / UPDA		QA Closed:	Date:	. 0
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		Torque W	aves in E	extrusion	n		Drawing		Out of	Calibration				
		Turning Se	equence				Finish		Out of	Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio

<b>Work Orde</b> November-19-12				*934	423*								Page 3	
Item ID: Revision ID:	646.3912			Accept	*N	900	<b>040</b>	100	<b>)</b> *	Setup	Start		S1*	
Item Name:	Shim										Stop	*N	S2*	
Start Date: Required Date: Reference:	11/15/12 12/07/12	<b>Start Qty:</b> 80.00 <b>Req'd Qty:</b> 80.00	*80* *80*			st Item I stomer:	D:							
Approvals:	Process Pla	an:	Date:	Tooling:		D:	ate:			Run	Start	*N	R1*	
	QC:		Date:	<b>SPC (Y/N):</b>		Da	ate:				Stop	*N	R2*	
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	T	ool ID	Tool #	Plan Code	Accept Qty	t Re Qt		Reject Number	Insp. Stamp	
*160 *160* QC Quality Control		QC5- Inspect part comple  Memo	eteness to step on W/O	0.00	15 15 1-2. 1			(	can	<u> </u>				
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*170* Packaging Packaging		<b>Memo</b> ***IDENTIF REV***	ST 1390 FY AS PER APICAL MPP-	0.00 120 BY STAMPING	THE P# AND							13/3/	5 (9	
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Quality Control

MB023

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		Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorre	ct	Weld		
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete	/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled		
		Cuffs				Contamination	-	Mainte			Part Moved	_	_		
		Heat Trea	it			Countersink	П	Mislabe	eled		Positioned V	Positioned Wrong			

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

H:/FORMS/Quality.	Acc.,	ammented OA	ALCOVALO DAVIC

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

## **Picklist Print**

Nevember-19-12 10:07:13 AM

Work Order ID:

93423

Parent Item:

646.3912

Parent Item Name:

Shim

**Start Date:** 11/15/12

Required Date: 12/07/12

Page 1

**Start Qty: 80.00** 

Required Qty: 80.00

Comments:

IPP REV:A 12 10 23 NEW ISSUE DD VERE:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MC1095S.020 C1095 Blue Tempered Spr	ing Steel Sheet .020	Purchased	No	·		110	sf	12.0000	0.02	1.6842105	BO	7-11-2	7
				<u>Location</u> MAT		<u>Loc Oty</u>	<u>Lo</u>	c Code			É		

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		Cracks			L	$\Box$	Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	Weld
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		Cuffs			Ļ		Contamination		Mainte	enance		Part Moved		
		Heat Treat	t		L		Countersink		Mislabe	led		Positioned V	Vrong	_
		Inspection	n Strip in	Tube		$\Box$	Cut Too Short		Misread	i		Power Loss/	Surge	Other
		Ripples in	Bend				Drill Holes		Offset		·			
		Torque W	aves in E	xtrusion	ո [		Drawing		Out of 0	Calibration				
		Turning Se	equence				Finish		Out of S	Sequence				
		Wave/Twi	ist in Tub	e	ſ		Folio		Outside	Dimensions				

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	93423
Description: SH∵W	Part Number:	646-3912
Inspection Dwg: 646-347 Rev: N/C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

		ARTICLE IN	O LO IN	OIL OIL	OKLIS I	·
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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Date:	17-11-27

Audited by:	0.89
Date:	121128

Preliminary Approval:	
Date:	

NOTES: SHOP COPY MATERIAL: SHIM STOCK, C1095 BLUE-TEMPERED SPRING STEEL RETURN TO FINISH: CAD PLATE PER QQ-P-416 TYP II CL2 **ENGINEERING UNCONTROLLED COPY** 3. IDENTIFY IAW MPP-120 SUBJECT TO AMENDMENT WITHOUT MOTICE 2.90 -WORK ORDER .020 <del>-</del> 2.90 -93423 MUS .020 12-11-20 1.57 1.00 - R.13 4PL 646.3912 R.13 4PL 646.3910 2.90 ---.032 2.90 .032 1.57 1.00 R.13 4PL - R.13 4PL 646.3913 SHIM 646.3911 646.3913 546.3912 SHIM 646.3911 SHIM 646.3910 SHBM DESCRIPTION QTY PARTS LIST APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300 SHIM B 97M16 PMG HD 646.3900

## CERTIFICATE OF CONFORMANCE

## CADORATH PLATING CO. LTD. 2150 LOGAN AVENUE **WINNIPEG, MANITOBA R2J-0J1**



DATE:

Jan-08-2013

CONSIGNED TO: Dart Aerospace Ltd.

1270 Aberdeen St.

Hawksbury, ON K6A 1K7

W/O #:

120745

**INVOICE #:** 

64009

CONTRACT OR

PURCHASE ORDER #

PO18582

DESCRIPTION:

SHIM

QTY

102

P/N # 646.3912

S/N # 93423

STRIP AND CADMIUM PLATING IAW AMS-QQ-P-416C TYPE 2 CLEAR CLASS 2. BAKE HEAT CHART # 13-14.

CERTIFICATE: I certify that the items indicated here on have been inspected and tested and conform to all specifications and requirements detailed on the contract or purchase order.

Approved Inspector: